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D2143
Job Sheet 201775



Part No: D2143

Job Qty: 6 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP C 00.05.18 Added inspection level 8 EC IPP Rev:D Now on WaterJet 06-10-15 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		10/21/19	0.17	0.22	Waterjet - Flow		OK 19/10/24
120	QC 8	6 pcs		10/21/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Small Fab - Brake NC - B4B	6 pcs		10/21/19	0.25	0.24	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

PRIORITY

OCT 24 2019 40 9-89

OCT 26 2019 30 9-89

				B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	6 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Handfinish - 1-1 Chemical-B4B	6 pcs	10/21/19	0.00 0.13	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 Powdercoat - 1 White GI(A)-B4B	6 pcs	10/21/19	0.00 0.10	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
180 QC 3	6 pcs	10/21/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	

DA 40
OCT 25 2019 9:36

BE819-10-25

BE 19-10-25

M211386.
START: 2:45. A.T. 3:00 FINISH: 3:15.

				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DAS OCT 28 2019 40 9-59
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
190 Packaging 3-1 - Stock - B4B	6 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC Stock
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 9-59
200 QC 21 - SA	6 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	OCT 28 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D2143

Descriptions: 120 - (QC8- Inspect parts - second check)

140 - (Bend/Assemble as per dwg) Bend as per Dwg D2143

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M5052H32S.040	5052-H32 .040 Sheet	.3960 sf (.066 ea)	100-Waterjet - Flow - 1	5186718	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M5052H32S.040	0	119	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.340Inches ± 0.010	0.350 0.330		
2	Hinge Bracket	0.625Inches ± 0.010	0.635 0.615		
3	Hinge Bracket	1.000Inches ± 0.010	1.010 0.990		
4	Hinge Bracket	0.063Inches ± 0.010	0.073 0.053	Radius	
5	Hinge Bracket	2.656Inches ± 0.010	2.666 2.646		
6	Hinge Bracket	3.317Inches ± 0.010	3.327 3.307		
7	Hinge Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
8	Hinge Bracket	0.171Inches + 0.005 - 0.000	0.176 0.171	Diameter	
9	Hinge Bracket	1.660Inches ± 0.010	1.670 1.650		
10	Hinge Bracket	2.844Inches ± 0.010	2.854 2.834		
11	Hinge Bracket	1.659Inches ± 0.010	1.669 1.649		
12	Hinge Bracket	0.125Inches ± 0.010	0.135 0.115	Radius	
13	Hinge Bracket	2.312Inches ± 0.010	2.322 2.302		

Plex 10/10/19 1:24 PM Dart.lajeunesse.marie

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
						Completed By			
						Lead hand / Supervisor			
		QC / QA Coordinator							